

Work Order ID 73973

Tuesday, September 20, 2011 10:21:48 AM



Page 1

Item ID: D2563

Accept



Setup Start



Revision ID:

Item Name: Step Weldment Assembly

Stop



Start Date: 9/20/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 10/11/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: *MF*

Date: *11-09-20*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2563	Rev C

100	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	1-Cut D2244 to 89.70" at 34 deg as per dwg D2563								

2-Deburr ends

3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343

4- Grind

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

11-10-20 6 0

6 0 Ben/10/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 11/10/21

+16

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

x6 of 11/10/21
counted.

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6x of 11/10/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Large Fab

Weld per dwg A/R Aluminum rod Batch: 114514
Large Fab

0.00

Memo

0.00

11-10-25

6

φ

Large Fab

1-Inspect for foreign object per QSI 024

2-Weld Remaining End cap as per Dwg D2563 using DT 8343

3-Grind

160



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8/11/12/26

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/11/12/26

46

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 4

[REDACTED]

[illegible]

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4. **STATE** _____

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229. **PRINT DATE** _____

230. **PRINT SIGNATURE** _____

231.

Customer:

Abstract



Date:

**Insp.
Stamp**

6XØm, 11/10/26

Touch up Alodine as per QSI005

[illegible]

6x8 m L 11/10/26

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(Ref: 4.3.5.1) as per QSI 005

3-40 =

320

4-10

Wing Walk as per dwg QSI005 4.4 Batch *M 116982* 0.00

RESEARCH DESIGN

0.00

6 of all 110/27
counted.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73973

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Item ID: D2563

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Weldment Assembly

Start Date: 9/20/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 10/11/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 BR-11-10-27-

210

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

PP 73974

9/11/31 (6)

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

n11/10/14
MF 11-10-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Tuesday, September 20, 2011 10:21:45 AM






Parent Item Name: Step Weldment Assembly

Required Date: 10/11/2011

Required Qty: 6.00

Comments: IPP Rev:G 02.07.31 Re-format Location RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2244-116  Step Extrusion		Manufactured	No			100	Each	101.5000	1	6		11.10.19	
				<u>Location</u>				<u>Loc Qty</u>					
				HALL				91					
				60307				91					
				WA				10.5					
				60307				10.5					
D2561  Lug		Manufactured	No			100	Each	19.0000	2	12		11.10.19	
				<u>Location</u>				<u>Loc Qty</u>					
				WA				14					
				71590				14					
				WA015				5					
				66813				5					
D2564  Mounting Angle		Manufactured	No			100	Each	42.0000	2	12		11.10.19	
				<u>Location</u>				<u>Loc Qty</u>					
				WA				42					
				69286				12					
				71591				30					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 20, 2011 10:21:45 AM

Page 2

Work Order ID: 73973

Parent Item: D2563

Parent Item Name: Step Weldment Assembly

Start Date: 9/20/2011

Required Date: 10/11/2011

Start Qty: 6.00

Required Qty: 6.00

D2673-34

Manufactured No

100 Each

55.0000

1

6



End Plate



11.10.24

Location

Loc Qty

Loc Code

WA

35

69534

35

WA015

20

59690

20

D2673-34

Manufactured No

150 Each

55.0000

1

6



End Plate



11.10.24

Location

Loc Qty

Loc Code

WA

35

69534

35

WA015

20

59690

20

Tuesday, September 20, 2011 10:21:45 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

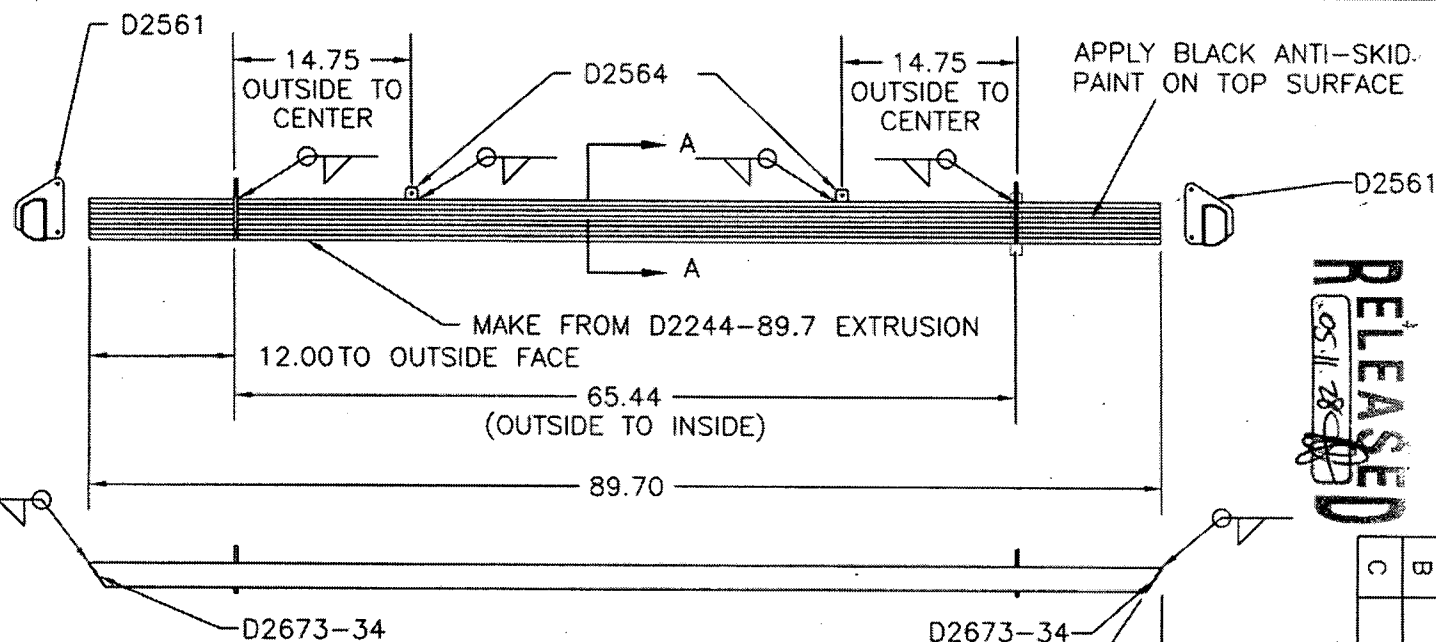
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

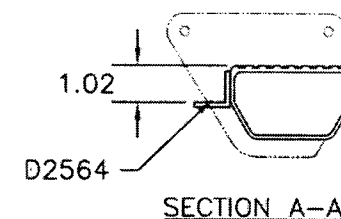
05-11-78



D2563 STEP WELDMENT ASSEMBLY PARTS LIST



Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing



D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DRAWING NO. D2563		REV. C SHEET 1 OF 1
CHECKED 	APPROVED 	SCALE 1:15
DATE 05.11.14	TITLE STEP WELDMENT ASSEMBLY	
A	96.04.26	NEW ISSUE
B	97.05.14	END CAPS CHANGED (WAS D2248)
C	05.11.14	UPDATE NOTES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries